

Date: Thursday, 6/7/2007 3:28:49 PM
 User: Kim Johnston

Process Sheet

26

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKIDTUBE ASSEMBLY
 Job Number : 32851
 Estimate Number : 10022
 P.O. Number : N/A Part Number : D205634011
 This Issue : 6/7/2007 S.O. No. : N/A Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : N/A
 Previous Run : 32618 Material : N/A
 Due Date : 6/30/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JS 07.06.08
 Comment : Est Rev: P 02.08.28 Removed QC5 from Step 5 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



KS 07.06.21

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011 CHG004

2.0 32851A SKID TUBE ASSEMBLY



Comment: Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B 32851A

7/8/23 SP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 K10003 D205-634-011 Saddle Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 K10003 Saddle Kit 12/218

1 D205-634-041 Skidtube Assembly(ref) 32851A

7/8/23 SP

5.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

EP 7/09/23 (X1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/18/24

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:28:49 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 32851

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location:

7/8/23 SP EP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D205634011

Job Completion



U 87-08.24

B32851A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Thursday, 6/7/2007 3:29:05 PM
Kim Johnston

Process Sheet

26

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKID TUBE ASSEMBLY
Job Number	: 32851A		
Estimate Number	: 10023		
P.O. Number	: N/A	Part Number	: D205634041
This Issue	: 6/7/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2580 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 32618A	Drawing Revision	: C
		Material	: N/A
		Due Date	: 6/30/2007
Written By	:	Qty:	1 Um: Each
Checked & Approved By	: <u>JA 070608</u>		
Comment	: Est Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ		
	: Est Rev. O 06.02.28 Added paperwork EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG001

NA

2.0	D25001190	Ext'n -1' Beam Tube 4"
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Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	B 29602

JD 7-6-29

3.0	D2596	205 Web
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	B 33058

7-7-11

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

- 1- Inspect mat'l D2500-1-190 for damage
- 2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends
- 3-Acid etch and Alodine tube per QSI 005 4.1
- 4-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

JD 7-6-29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:29:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32851A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

6-Countersink holes as per Dwg D2580 without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
AVR	Sikaflex-291	M104732	

Sikaflex expire date: 3-1-11

Start Time: 3:30 Date: 7-7-11

Fin Time: 3:40 Date: 7-7-11

DD
7-7-11

K
7-7-11

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL 7-7-12

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

K 7-7-26

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 07-07-30

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	23464

BE 070730

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:29:05 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32851A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

20

D2579

Spacers

B-33081

BE 07-07-30

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 StepRemove alodine as required.

BE 07-07-30

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

M 104907

BE 07-07-30

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

M 104907

BE 07-07-30

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

DP 7-7-30

5-Drill holes for wearplates using DT 8217Open holes to 19/64", adjust stopper not to hit web.Deburr

07/07/30 ANM DP

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

07/07/01 ANM DP

7-Drill pilot holes for aft cap using DT 8215Open holes to #6 Drill bit. Deburr

8-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/08/14

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/14 (X)

13.0

HAND FINISHING1

HAND-FINISHING RESOURCE #1



Comment: HAND-FINISHING RESOURCE #1

Pressure wash as per QSI 005

M. J.

07/08/15

(1X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-634-041 PAR #: N/A Fault Category: Prod / Landing Gear NCR: Yes No DQA: 2 Date: 07/08/04
 QA: N/C Closed: 18 Date: 07.08.24

NCR: <u>32851A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-08-07	10.6	The 5th hole from the fwd (one hole only) the x-bolt spacer was bored oval.	<u>JE</u> 07-08-08	Remove Qty 2 x-bolt spacer and replace B-33081 weld into place per DWG and QST 004.	BE 07-08-08	07/08/14	<u>JE</u> 07-08-08	<u>JE</u> 07-08-07
		RC New employee - human error. held tool towards employee.		grind flush - bore.	Pmc 07-08-10	07/08/14		
		Found another 10 cross bolt spacers that were counter bored ovalizer (1st, 2nd, 7th, 8th, 10th, 11th, 12th, 13th, 14th, 15th, from aft)	<u>JE</u> 07-08-08	Remove all 10 cross bolt spacers B-33081 install replacement D2579 per QST 004 and D2580 1/2 Aluminum Rod M# 104907	07-08-08	07/08/14	<u>JE</u> 07-08-08	<u>JE</u> 07/08/08
				grind flush and restore	Pmc 07-08-10	07/08/14		

NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:29:05 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32851A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

14.0

POWDER COATING

POWDER COATING



M105068



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/M- 07-08-15

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 01/08/21 (1)

16.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2577-1

Wearplate

B31212 M-L

17.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2577-3

Wearplate

B30551 M-L

18.0

D25775

Wearplate, Centre



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2577-5

Wearplate

B30812 M-L

19.0

ALS71032130

Insert



* (1x)

Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

44

ALS7-1032-130

Inserts

M-L 07/08/21
M10247

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:29:05 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32851A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD10L

Washer



X

Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 4 AN960JD10L Washer

M104885

21.0

AN34A

Bolt



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 4 AN3-4A Bolt

M104817

m.k

22.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

plug

Batch: B32651

m.k

23.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

o-ring

Batch: B27168

m.k

24.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B27488

m.k

25.0

AN35A

Bolt



(1X)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M100188

m.k 07/08/21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:29:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32851A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

26.0

AN960JD10L

Washer



*

Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch:

M104885

m-l

27.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

M104989

Sikaflex expire date:

08-01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R

Sikaflex-291

M104989

Sikaflex expire date:

08-01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

m/04942

Batch:

07/08/21 ①

28.0

QC5

INSPECT WORK TO CURRENT STEP



Er 08/08/23 ①



All Plugs
in tube

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

07/08/23 ①

07/08/23 ①

30.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

07/08/24

Job Completion



W 07/08/24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. C SHEET 1 OF 2
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED
98/09/17 DS

QTY	Part Number	Description
X	D2580-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2596	205 WEB
1	D2575	AFT CAP
1	D2576 - 3	STEP
20	D2579	CROSS BOLT SPACER
16	D2594-1	PLUG
16	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
46	AN3-4A	BOLT
46	AN960JD10L	WASHER

98.08.28
CP 98.08.28

EFFECTIVE DEOS
98/12/14
DEO 9124
DED 9183

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES *
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
CHECK TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32851A

DETAIL B
SCALE 5:24

00-08-30
UP 00-53-28

D2576-3

GRIND FLUSH (4 PLACES)

GRIND FLUSH

GRIND FLUSH

LOCATION RIDGE ON UNDERSIDE OF D2576

1/4

DRILL PRIOR TO D2575 CAP
INSTALLATION (2 PLACES)

SEAL WITH
SIKAFLEX-241

AN3-4A BOLT (1)
AN960J10L WASHER (1)
(2 PLACES)

D2575 CAP

0.40

D2579 SPACER

MULTIPLE SPACERS

WEB (REF)

T30 (REF)

4 PLACES

AFTER PERFORM

1. CHA
2. INS
3. WEL
4. C'B

D2580-1 DRILLING DETAIL

37.50
DISTANCE TO AFT END
OF D2586 WEB

3
7

1.750 1.750

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

91.500

38.0


190.0
(D2500-1)

#0.508 (TYP.)
(40 PLACES)

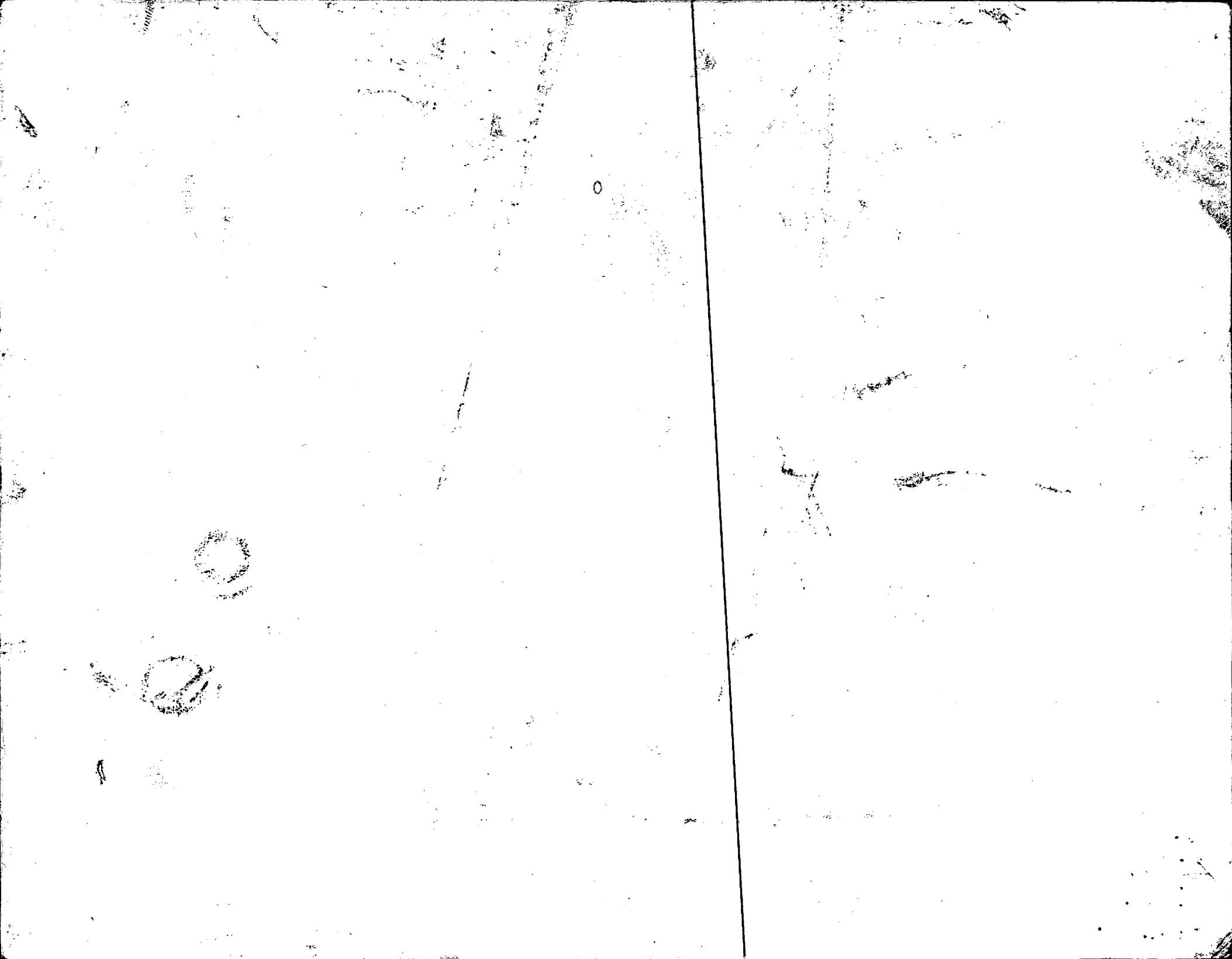
REFER TO DETAIL A

[illegible]

RELEASE
98/09/17 DS

DESIGN <i>DAH</i>	DRAWN BY <i>CP</i>	 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA <i>11/23/83</i>
CHECKED <i>DAH</i>	APPROVED <i>JS</i>	
DATE 98.08.26	TITLE 205 SKIDTUBE ASSEMBLY	REV. 1 SHEET 2 OF 2 SCALE 1:2

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32857A



NO. 10

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name Eric J. Miller
 Joint Welding Procedure TIG
 Pac. number and Job number 205634041 / B32677A

TEST WELDS REQUIRED

BASE METAL Aluminum WELDING PROCESS TIG
 Penetration Complete ☐ Partial ☒ Single Weld ☐ Double Weld ☐
 Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position		Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

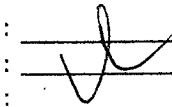
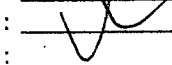
Visual Pass ☒ Fail ☐
 Penetration Pass ☒ Fail ☐
 Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 1/7/06 Qualifier Eric J. Miller

Date: Tuesday, 28/08/2007 12:40:11 PM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: UPDATE PAPERW. 634/635
Job Number	: 34285		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 28/08/2007 S.O. No. : N/A	Drawing Number	: ECN 1023
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	: 	Due Date	: 04/09/2007 Qty: 1 Um: Each
Checked & Approved By	: 		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

REMOVE FROM STK / ADD NEW PAPERWORK
EASA STC: EASA.IM.R.S.01303

B 32851, B 32854, B 32953, B 32951, B 32952, B 32212,
D205-634-011 B 32613, 32618, B 32950, B 32615, B 32853, B 32213, B 32215

D205-634-041

D205-635-011 B 29278, B 29667, B 29955, B 29956, B 29957, B 29959

73 D205-635-041 B 21564, B 21821, B 22797, B 20000

D205-634-043

D205-634-045 B 12245
D519372-011 B 33404
RETURN TO STK

 07/04/28